

Date: Tuesday, 20/01/2009 10:33:17 AM
 User: Melanie Fauteux

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : INDEXING BLOCK
Job Number : 44948	
Estimate Number : 13319	
P.O. Number :	Part Number : D37901
This Issue : 20/01/2009 S.O. No. :	Drawing Number : D3790 PREL REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : 11 Type : MACHINED PARTS	Drawing Revision : PREL B
Previous Run : 40365	Material :
Written By :	Due Date : 21/01/2009 Qty: 2 - Um: Each
Checked & Approved By : <u>MF 09-01-20</u>	
Comment : Est Rev:A New Issue 08-05-16 JLM Verified By:DD	



Additional Product

PRELIMINARY ISSUE
 20.01.20 BCN 109-702P

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MDLRINB2000X3000	Delrin Bar 2" x 3"
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Comment: Qty.: 0.5250 f(s)/Unit Total : 0.5250 f(s)

Delrin Bar 2" x 3"

Batch: 1108068

JL 09/01/20

2.0	BAND SAW	BAND SAW
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**Comment:** BAND SAW

Cut blank 5.900 " long

JL 09/01/20

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #11- Mill as per Folio FA745 Rev: AA & Dwg D3790 Rev: B

2-Deburr per dwg D3790

JL 09/01/21

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

JL 09/01/21

5.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

**ENGINEERING
 APPROVAL** (2)

20.01.21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: INDEXING BLOCK

Job Number: 44948

Part Number: D37901

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

ST 121

MF 09-02-20

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/23

Job Completion



MF 09-01-21

POSITIVE RECALL

EFFECTIVE 09-01-20 AUTH L

RELEASED _____ DATE 09.02.12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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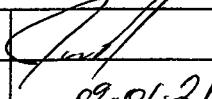
NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 44948
Description: indexing block		Part Number: D3790-1
Inspection Dwg: D3790	Rev: B	Page 1 of 1

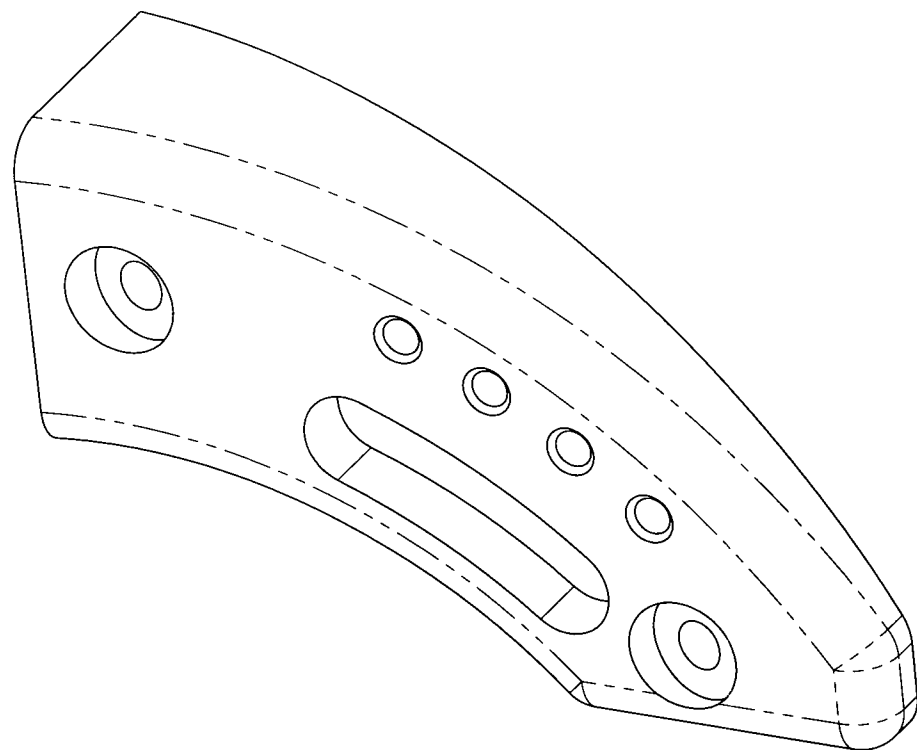
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.525	$\pm .010$.528	✓			
1.25	$\pm .030$	1.250	✓			
Ø .209	$\begin{matrix} + .006 \\ - .001 \end{matrix}$.210	✓			
.450 deep	$\pm .010$.440	✓			
.05x45°	$\begin{matrix} + .03 \\ - .5^\circ \end{matrix}$.050x45°	✓			
1.300	$\pm .010$	1.301	✓			
1.629	$\pm .010$	1.630	✓			
1.910	$\pm .010$	1.911	✓			
2.138	$\pm .010$	2.139	✓			
.625	$\pm .010$.625	✓			
1.42	$\pm .030$	1.416	✓			
12°	$\pm .5^\circ$	12°	✓			
.38	$\pm .030$.378	✓			
Ø .281	$\begin{matrix} + .006 \\ - .001 \end{matrix}$.283	✓			
.500	$\pm .010$.499	✓			
2.100	$\pm .010$	2.093	✓			

Measured by: J.L.	Audited by: 	Prototype Approval: N/A
Date: 09/01/21	Date: 09-01-21	Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



44948

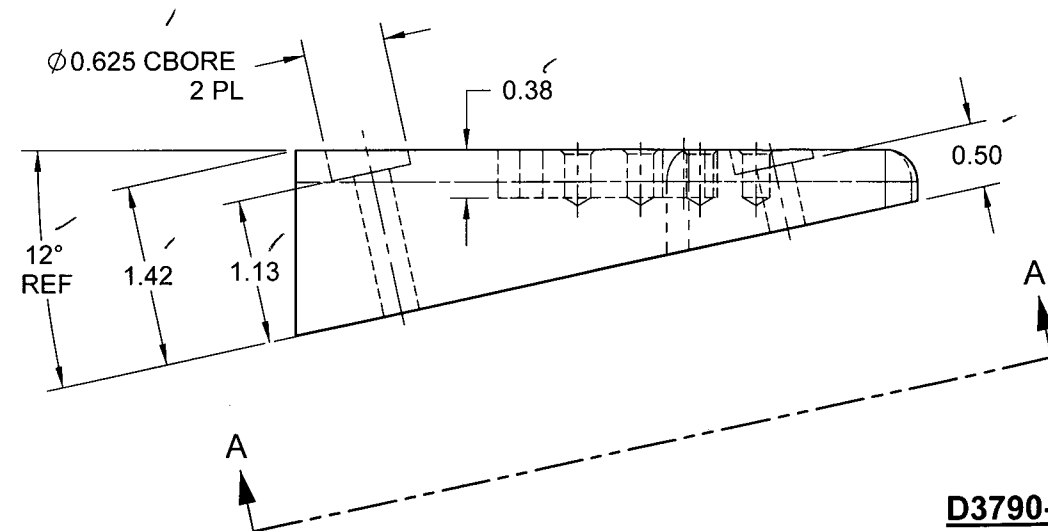
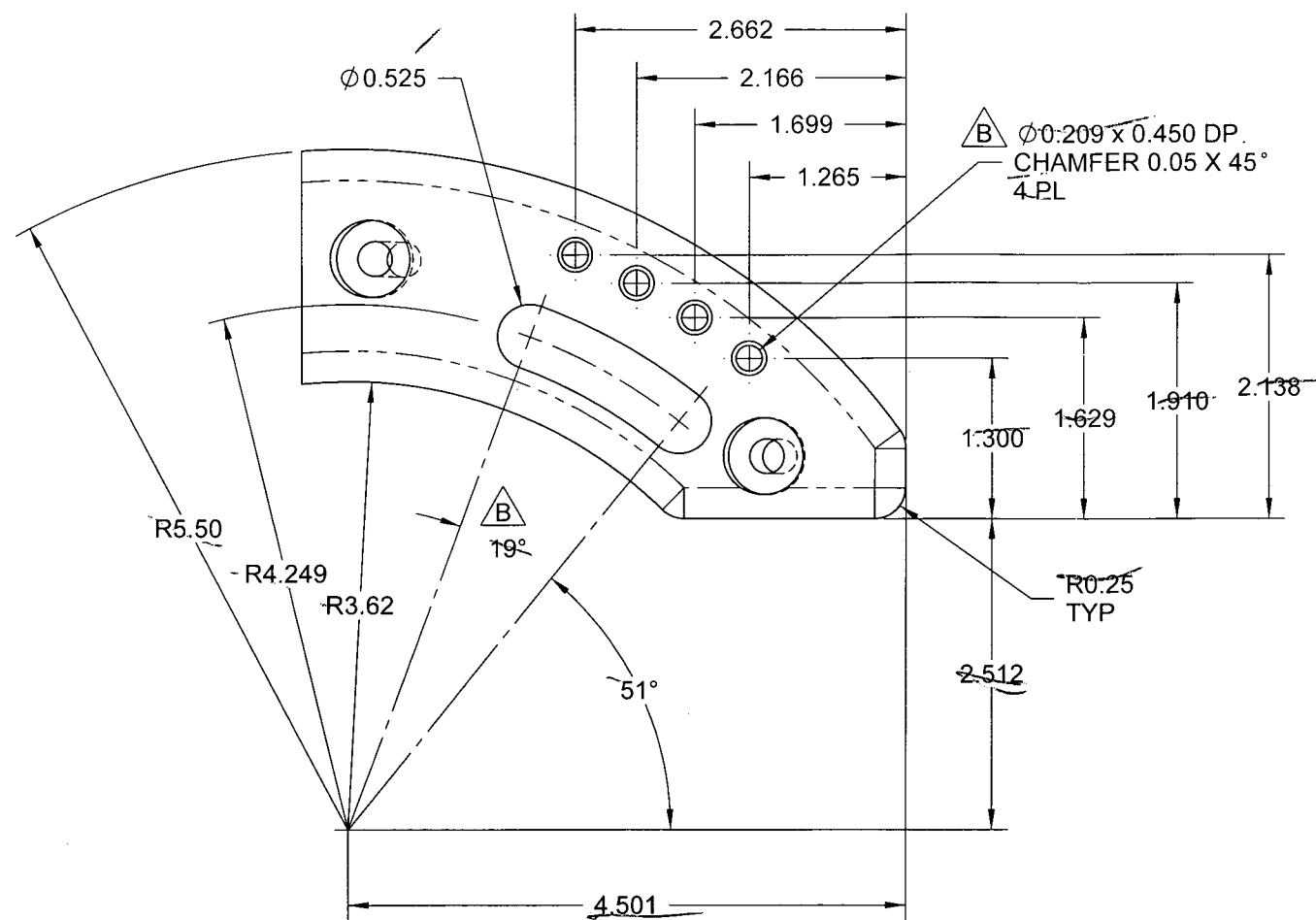
PRELIMINARY ISSUE
A. C. A. 20
PER ECN# 09-502P

D3790-1 INDEXING BLOCK

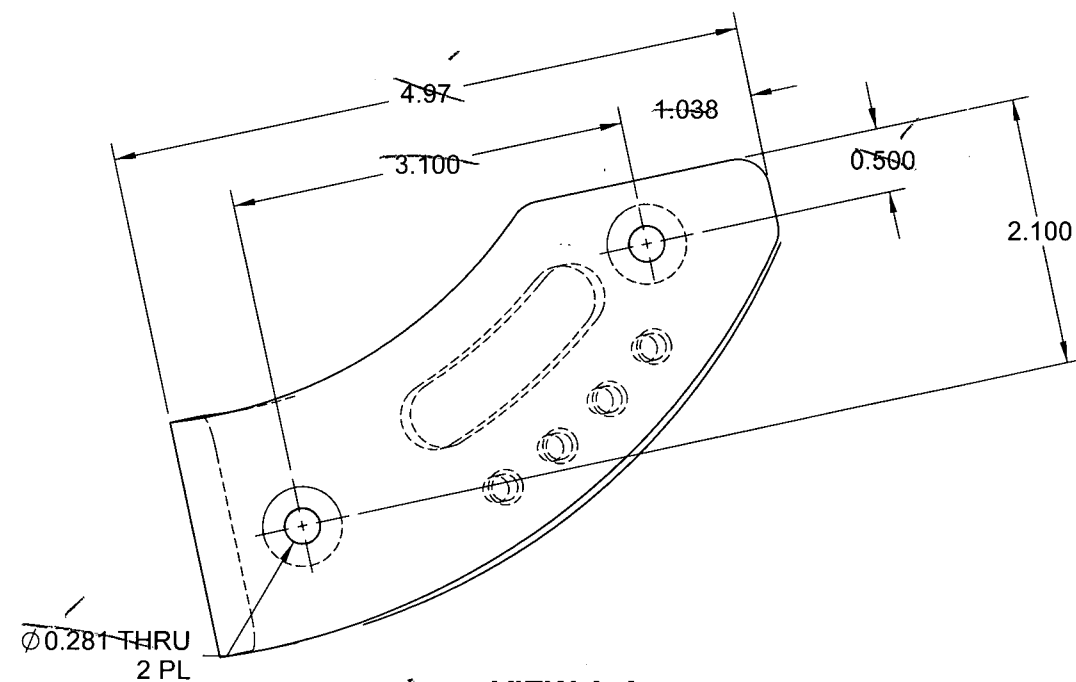
NOTES:

- △ B 1) MATERIAL: BLACK ACETRON GP ACETAL
(REF DART SPEC M-DELRIN-B)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: SCRIBE WITH DART P/N "D3790-1" USING VIBRATING STYLUS
- 7) WEIGHT: 0.39 lbs

B	UPDATED NOTE 1 (ZN A8-1); Ø 0.209 WAS Ø 0.250 AND 4 PL WAS 5 PL (ZN D5-2); 19° WAS 25° (ZN C7-2). REASON: REDESIGNED TO ELIMINATE POSSIBLE INTERFERENCE BETWEEN D3705-041 AND D3676-1 AT INSTALLATION	MB	08.06.26
A	NEW ISSUE	MB	08.05.13
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3790	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		INDEXING BLOCK	NTS
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D3790-1 INDEXING BLOCK



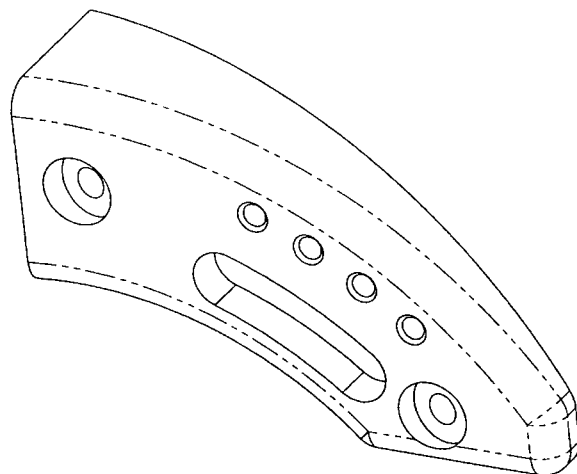
VIEW A-A

PRELIMINARY ISSUE

09.01.20

PER BCN # 09-502P

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DRAWN		HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.		D3790	SHEET 2 OF 2
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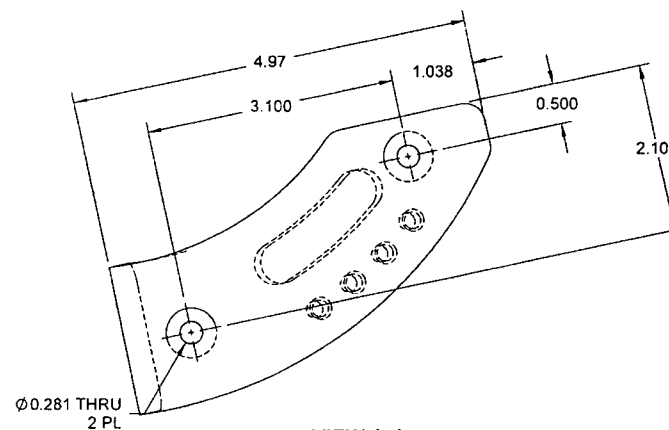
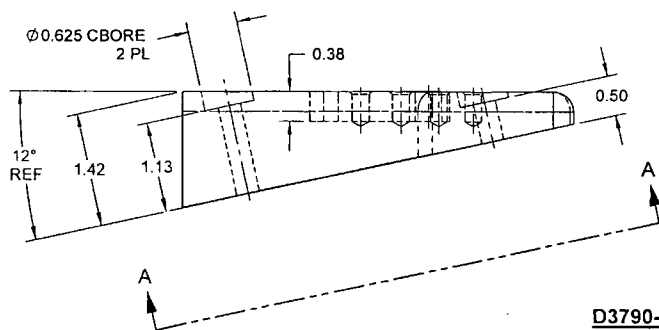
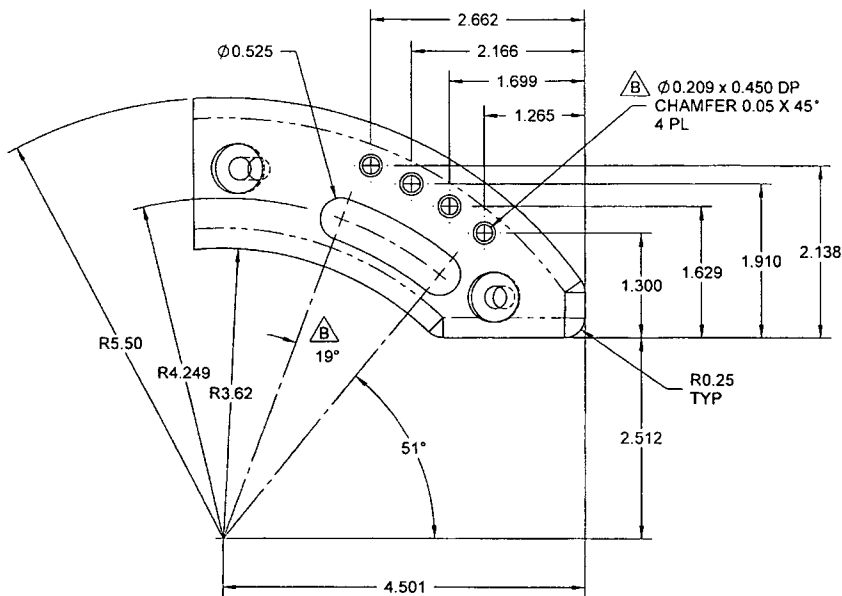
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09/02/05

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CHECKED	MFG. APPR.		DRAWING NO. D3790	REV. B SHEET 1 OF 2
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D3790-1 INDEXING BLOCK

VIEW A-A

RELEASED
9/26/05

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MFG. APPR.		D3790	SHEET 2 OF 2
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